DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027209
Date Inspected: 21-Feb-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Jobsite

CWI Name:	As noted below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

13E PP118.2 E5 Vent Hole (Exterior)

This QA Inspector observed ABF welder Salvador Sandoval (ID 2202) pre-heat the joint to 66 degrees C prior to performing Shielded Metal Arc Welding (SMAW) in the (1G) flat position on the vent hole at 13E PP118.2 E5 on the exterior of the OBG. This QA Inspector observed the QC Inspector monitor the inter-pass temperatures and the welding to ensure the parameters were in compliance pertaining to ABF-WPS-D1.5-1050A-CU. The parameters were recorded as (Amperes=126) utilizing a 3.2 mm E7018-H4R electrode. The welder was observed grinding and blending the start/stop edges of the work between passes and throughout the joints depth. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract specifications. This joint is a Seismic Performance Critical Member (SPCM).

QC NDT (Exterior)

This QA Inspector randomly observed ABF Quality Control Inspector Mr. John Pagliero performing Ultrasonic Testing (UT) inspection on “A4” of 13E/14E on the exterior of the OBG. This QA Inspector observed that Mr. Pagliero detected no rejectable indications. The deck at this location is 20mm thick and is a Seismic

Performance Critical Member (SPCM).

QA NDT (Interior)

This QA Inspector performed a Magnetic Particle (MT) Inspection on “A4” at 13E/14E on the exterior of the OBG. This QA Inspector performed the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of the welds at the locations listed above. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1. 5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

13E PP118.5 E5 Vent Hole (Exterior)

This QA Inspector observed QC Inspector Sal Merino perform joint fit-up operations on an “A” deck vent hole on the exterior of the OBG located at 13E PP118.5 E5. This QA Inspector verified the B-U4a complete Joint penetration (CJP) fit-up and found it to be satisfactory and in conformance with the welding procedure. This QA Inspector randomly observed ABF welder Salvador Sandoval (ID 2202) pre-heat the vent hole to 66°C prior to performing SMAW in the (1G) flat position. This QA Inspector observed the QC Inspector monitoring the inter-pass temperatures and the welding to ensure the parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=128) utilizing a 3.2 mm E7018-H4R electrode. This QA Inspector randomly observed the ABF welder grind and blend the start and stop areas of the weld throughout the joints depth. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

FW Spencer Pipe Welding (Exterior)

This QA Inspector observed F.W. Spencer welder Damian LLanos ID# (6645) performing Shielded Metal Arc Welding (SMAW) in all positions on schedule 80 4” domestic water pipe and 2.5” compressed air pipe at the locations listed below. This QA Inspector verified the fit up of the joints and found it to be satisfactory and randomly observed QC Inspector Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed utilizing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

38/2.5/73/NW, 38/4/73/NW
39/2.5/75/NW, 39/4/75/NW
40/2.5/77/NW, 40/4/77/NW
33/2.5/63/NW, 33/4/63/NW

WELDING INSPECTION REPORT

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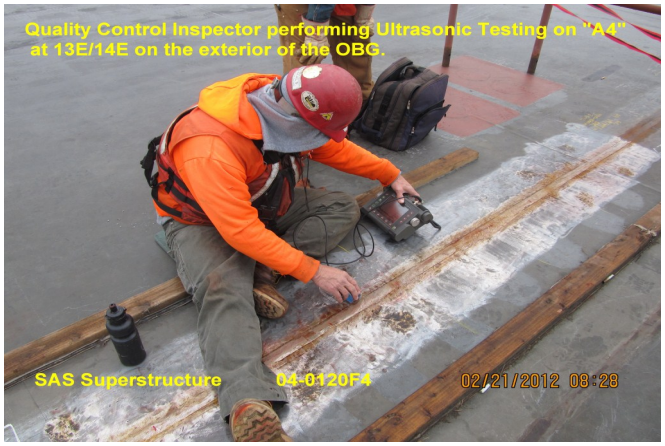
Summary of Conversations:

The were no pertinent conversations to report.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer